

Work Order ID 161537

Wednesday, May 17, 2017 11:45:54 AM

161537

Page 1

Item ID: D4034-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Upper Rib Assembly
Start Date: 5/17/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 5/19/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: MAY 17 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4034	C

100 Weld per dwg A/R S.S. rod Batch: 136585 0.00

100

Large Fab

Memo

1.32

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib and grind weld flush as per dwg

(2)DAC
17/05/17

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

DAS
9
9-89

120

QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.04

Quality Control

DAS
9
9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA004</u>	0.00							
130						<u>2x</u>	<u>DA</u>	<u>2017-05-23</u>	
Packaging	Memo	0.02							
Packaging	LOCATION: WA004								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.20							
Quality Control									

DAS
21
9-89

MAY 23 2017

Picklist Print

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Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 5/17/2017

Required Date: 5/19/2017

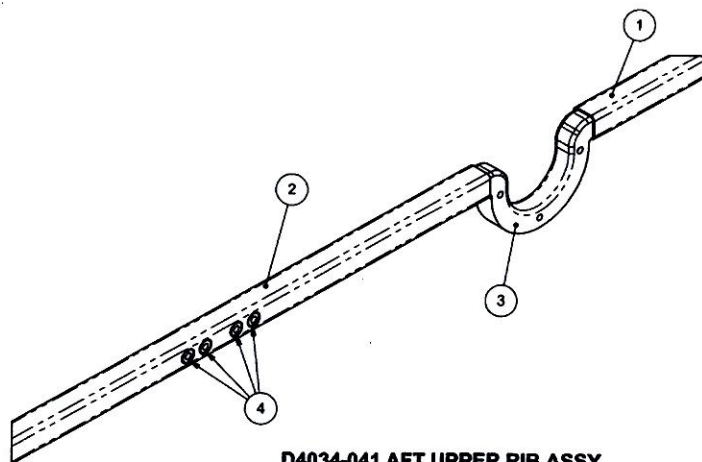
Start Qty: 2.00

Required Qty: 2.00

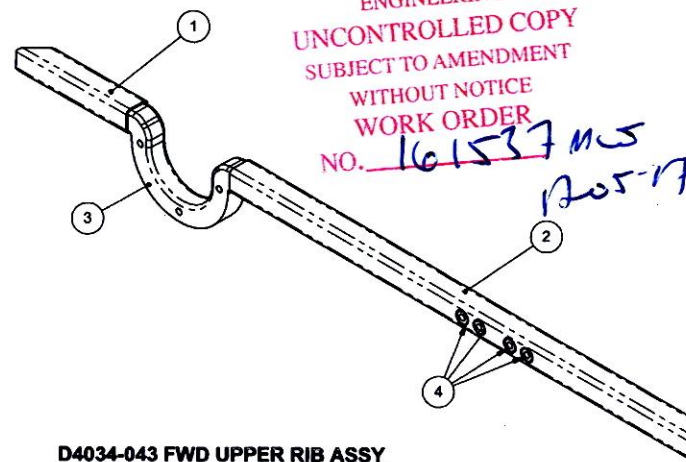
Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER
DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER DWG
REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD
VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1 *D4034-1* Rib		Manufactured	No			100	Each	10.0000	1	2			
									**			DYC 17/05/17	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				10					
				160511				10		2			
D4034-3 *D4034-3* Rib		Manufactured	No			100	Each	2.0000	1	2			
									**			DYC 17/05/17	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				2					
				160512				2		2			
D4021-7 *D4021-7* Hoop		Manufactured	No			100	Each	14.0000	1	2			
									**			DYC 17/05/17	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				14					
				160514				14		2			
D4021-9 *D4021-9* Bushing		Manufactured	No			100	Each	100.0000	4	8			
									**			DYC 17/05/17	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				100					
				158785				100		8			

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1	1	D4034-3	RIB
3	1	1	D4021-7	HOOP
4	4	4	D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY

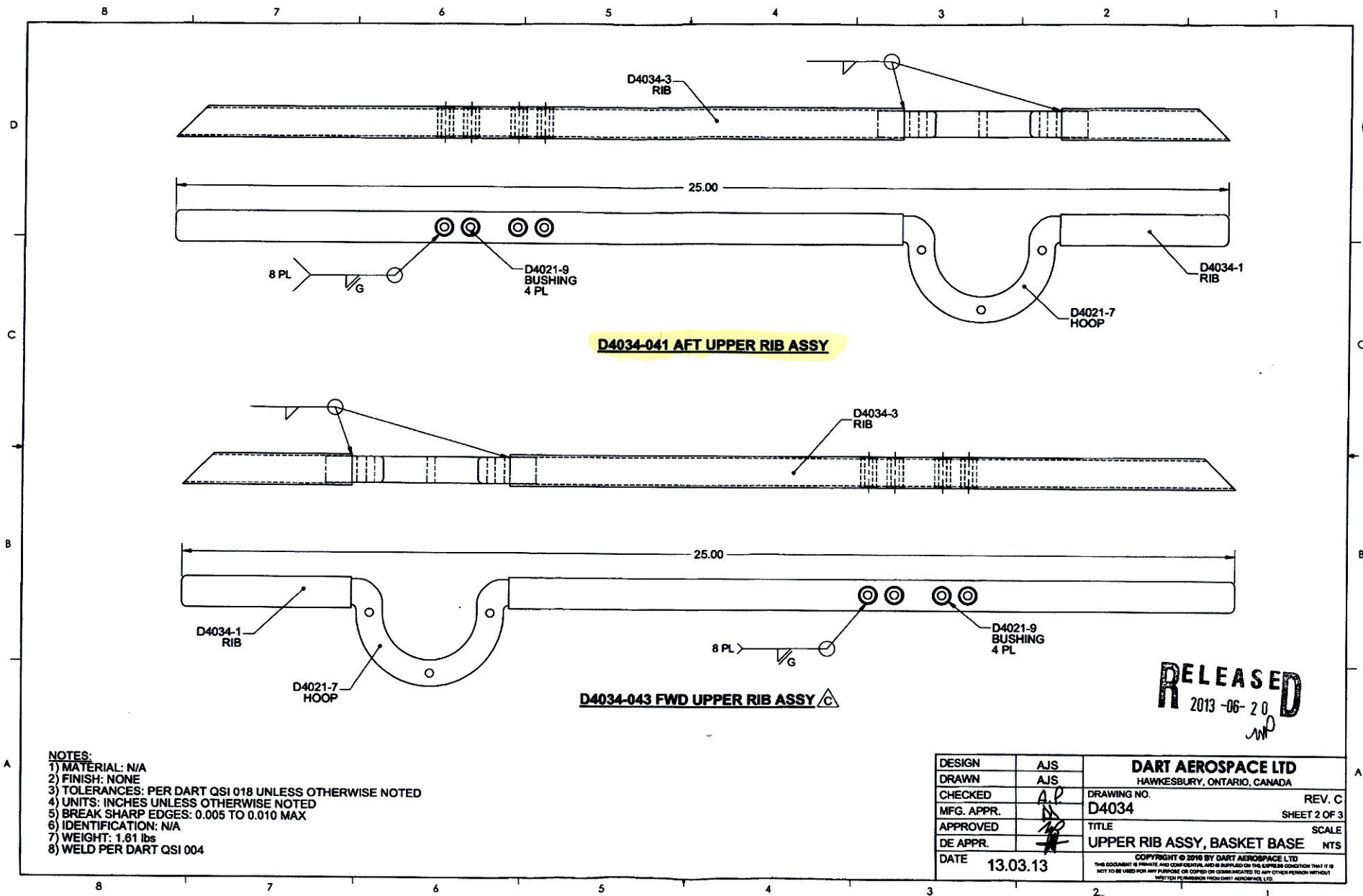


D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161537 MJS
1205-17

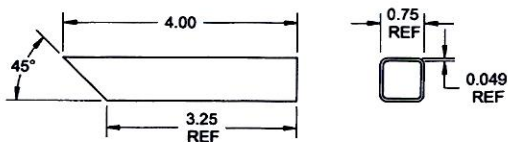
RELEASED
2013-06-20
AM

C	-043 REDESIGNED AS MIRROR IMAGE OF -041. -5 DELETED. D2327-3 DELETED. REASON PROP ARM NO LONGER OFFERED.	AJS	13.03.13
B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4034 TITLE UPPER RIB ASSY, BASKET BASE DATE 13.03.13	
DRAWN	AJS		
CHECKED	A.P.		
MFG. APPR.	NS		
APPROVED	NS		
DE APPR.	NS		
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		SCALE	NTS

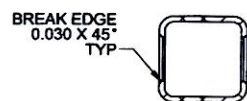


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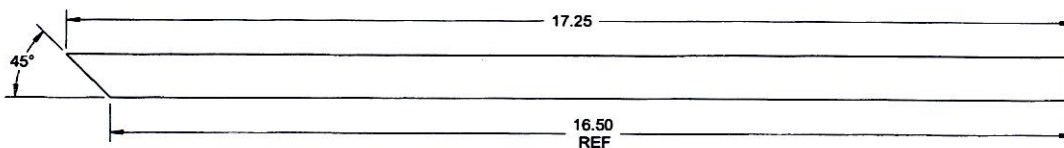
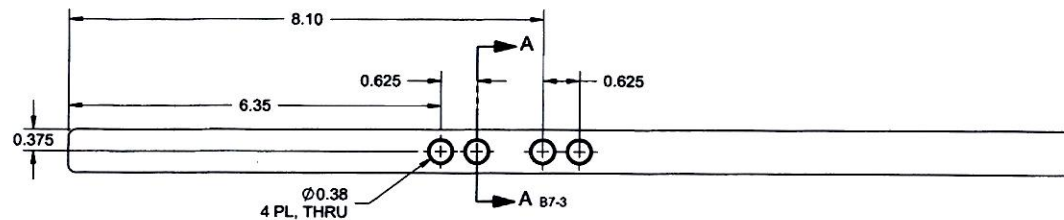
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DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	NS	D4034	SHEET 2 OF 3
APPROVED	NS	TITLE	SCALE
DE APPR.	NS	UPPER RIB ASSY, BASKET BASE	NTS
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D4034-1 RIB



SECTION A-A C3-3



D4034-3 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3: 0.62 lbs

RELEASED
2013-06-28

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	AS	D4034	SHEET 3 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	UPPER RIB ASSY, BASKET BASE	NTS
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